

D206.628.011

## Work Order ID 54903



Page 1

January 5, 2010 8:55:27 AM

Item ID: D2721-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 206B Step Assembly

Start Date: 05/01/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: *RL*Date: *10-1-05*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2721

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2721-1 using D2622 extrusion as per Dwg D2721. Deburr and bevel ends for welding

*10-01-12**2* *φ*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT followed by Jig DT. A/R AL Rod Batch: *1111311*  
*1111494* Grind*10-01-13**2* *φ*

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

*2E10/01/18* *(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer:

Reference:

Run Start



Approvals:

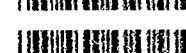
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



≥ 8 10/01/18

12.4

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00



pk 10.01.18

2

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



M.L 10/01/19

(2X)

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg  
D2721 using Jig DT followed by Jig DT A/R AL Rod  
Batch: M111311 Grind End Cap Welds Flush

*10.01.20*

2

*10.01.20*

170



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

*10.01.20*

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*10.01.20*

*+249  
-046*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ M 10-01-21

(V2)

Ø

HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

⇒ M 10-01-21

(V2)

Ø

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:15pm OVEN TEMPERATURE:  
3:45pm FINISH TIME: 320°F

210

QC3- Inspect Part Finish

0.00

BK 10-01-25

(2)

Ø

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220



HandFinish

Pressure Wash per QS1005 4.3

WING WALK M. 112900

0.00

10-01-25

②

Memo

0.00

Hand Finishing

230



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

10/1/26 (2)

240



Packaging

Identify as per dwg & Stock Location:

0.00

Memo

PPA549.2

0.00

Packaging

10/1/26 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/27 AJ

UMF 10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 8:55:31 AM

Page 1

Work Order ID: 54903

Parent Item: D2721-041

Parent Item Name: 206B Step Assembly



Start Date: 05/01/2010

Required Date: 18/01/2010



Start Qty: 2.00

Required Qty: 2.00



Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3461-7  Mounting Plate		Manufactured	No			100	Each	36.0000	2.0000 		10.01.13	

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	36	
33863	36	

D2622-120C  Step Extrusion		Manufactured	No			110	Each	84.8200	2.0000 		10.01.12	
---	--	--------------	----	--	--	-----	------	---------	---	--	----------	--

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
WA	84.82	
48612	3.12	
52026	81.7	

D2734  Step End Plate		Manufactured	No			110	Each	25.0000	4.0000 		10.01.13	
--	--	--------------	----	--	--	-----	------	---------	---	--	----------	--

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	25	
43535	2	
48110	23	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 8:55:31 AM

Work Order ID: 54903

Parent Item: D2721-041

Parent Item Name: 206B Step Assembly


Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 2.00

Required Qty: 2.00


Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3461-1  Mounting Plate		Manufactured	No			110	Each	15.0000	2.0000			

*PH 10-01-13*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	15	
41600	15	


2  
2

D3461-3  Mounting Plate		Manufactured	No			110	Each	18.0000	2.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

*PH 10-01-13*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
41601	18	

2

D3461-5  Mounting Plate		Manufactured	No			110	Each	34.0000	2.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

*PH 10-01-13*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	34	
33862	34	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

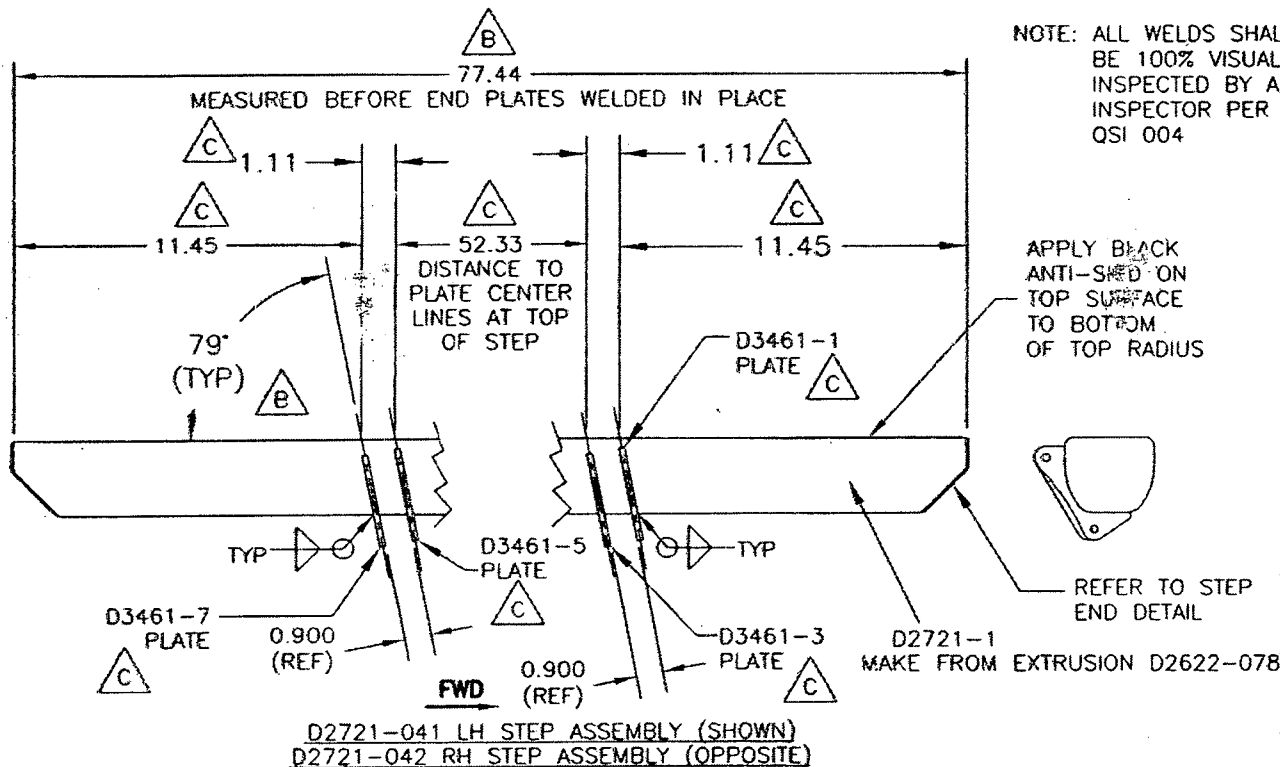
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APPLY BLACK  
ANTI-SHED ON  
- TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

D2721-1  
MAKE FROM EXTRUSION D2622-078

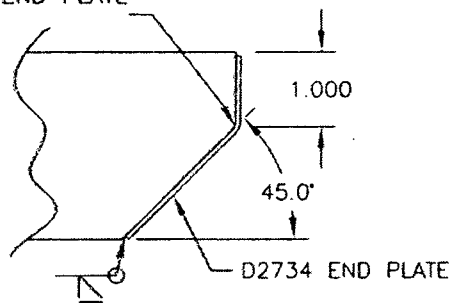
ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE


## 02721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-D41	-D42		
X		02721-041	LM STEP ASSEMBLY
	X	02721-042	RM STEP ASSEMBLY
1	1	02602-076	EXTRUSION
2	2	02734	END PLATE
1	1	03461-1	PLATE
		03461-3	PLATE
1	1	03461-5	PLATE
1	1	03461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





TYPICAL STEP END DETAIL 

RELEASED  
05-11-14

# DART

187- SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. ~~187~~ 5490  
BM 10-1-0

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. C
CHECKED		APPROVED		DRAWING NO.	D2721	SHEET 1 OF 1
DATE	05.09.19			TITLE	206B STEP ASSEMBLY	
A	97.12.04			NEW ISSUE		
B	98.10.19			79" WAS 80", UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0		
C	05.09.19			RE-DESIGN, ADD D3461-1/-3/-5/-7		

W/O:		WORK ORDER CHANGES					
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